

Work Order ID 111104

111104

Page 1

Thursday, January 09, 2014 11:30:04 AM

Item ID: PB67-43001-45 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Longitudinal Support
 Start Date: 1/8/2014 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/8/2014 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: UNE Date: 14-01-09 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001-45	c

100	Small Fab	0.00							
100	Memo	0.00							
Small Fab	1- Align drill -97 and -357 using existing pilot hole of -357 as per dwg								
Small Fab	2- install spring pin								

2 φ 14-01-20

110	QC5- Inspect part completeness to step on W/O	0.00							
110	Memo	0.00							
QC									
Quality Control									

QC 14-01-30 14-01-20 DAS
9
9-89

120	Green Sandtex(Ref:4.3.5.8) per OSI005 4.3	0.00							
120	Memo	0.00							
Powdercoat	START TIME: <u>11:35</u>								
Powder Coating	OVEN TEMPERATURE: <u>320°</u>								
	FINISH TIME: <u>12:05</u>								

2 φ 14-2-3 12 34 9-89

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Quality Control

Work Order ID 111104***111104***

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Item ID: PB67-43001-45

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Longitudinal Support

Start Date: 1/8/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/8/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Identify as per dwg & Stock Location: Horiz 0.00***160***

Packaging

Memo

0.00

Packaging

2x 14-02-04DAS
26
9-89

170

QC21- Final Inspection - Work Order Release 0.00

170

QC

Memo

0.00

Quality Control

ML5 14-02-05(N) 14-02-04

Picklist Print

Thursday, January 09, 2014 11:30:03 AM

Page 1

Work Order ID: 111104

Parent Item: PB67-43001-45

Parent Item Name: Longitudinal Support

Start Date: 1/8/2014

Required Date: 1/8/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-25 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-97 Clevis		Manufactured	No			100	Each	3.0000	1	1		1/14.01.20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		3							
				41869		2							
				90890		1							
PB67-43001-357 Tube Arm		Manufactured	No			100	Each	7.0000	1	1		1/14.01.20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		7							
				41508		5							
				99950		2							
* 240-107 SPRING SLOTTED PIN		Purchased	No			100	Each	16.0000	1	1		1/14.01.20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST382	M115827	16							
				124060		16							
* D3447-1 Round Spacer		Manufactured	No			140	Each	7.0000	1	1		1/14.01.20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2	M115827	7							
				41179		1							
				85212		6							
D3447-5 Clevis		Manufactured	No			140	Each	5.0000	1	1		1/14.01.20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		5							
				41459		5							
30345T21 LANYARD		Purchased	No			140	Each	0.0000	1	1		1/14.02.03	

B127979 = 2

Picklist Print

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Page 2

Work Order ID: 111104

Parent Item: PB67-43001-45

Start Date: 1/8/2014

Required Date: 1/8/2014

Parent Item Name: Longitudinal Support

Start Qty: 1.00

Required Qty: 1.00

AN4-13A Purchased No 140 Each 1,743.0000 1 1 1/14.02.03

Bolt

Location	Loc Qty	Loc Code
FG	20	
122808	20	
GA	17	
m125709	17	
ST356	222	
m126193	222	2
ST515	1484	
m126193	434	
m127432	50	
m127817	1000	

BSP43

RIVET

Purchased No 140 Each 78.0000 1 1 1/14.02.03

Location	Loc Qty	Loc Code
ST282	78	
M127380	78	

MS17984-C410

QUICK PIN REPLACEMENT

Purchased No 140 Each 1.0000 1 1 1/14.02.03

Location	Loc Qty	Loc Code
ST332 <u>m128051</u>	1	
m127376	1	2

MS21042L4

Locknut

Purchased No 140 Each 5,355.0000 1 1 1/14.02.03

Location	Loc Qty	Loc Code
GA	80	
m126333	80	
ST509	4000	
m127255	2000	
m127813	2000	
ST518	1275	
m127376	1275	2

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Shop Packet Print

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Picklist Print

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Page 3

Work Order ID: 111104

Parent Item: PB67-43001-45

Start Date: 1/8/2014

Required Date: 1/8/2014

Parent Item Name: Longitudinal Support

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0416J

Purchased

No

140

Each

416.0000

2

2

WASHER

12-14-02-03

Location

Loc Qty

Loc Code

GA

211

m126254

211

ST294

205

m125773

11

m127832

194

4

NAS1149DN416J

Purchased

No

140

Each

1,303.0000

1

1

Washer

12-14-02-03

Location

Loc Qty

Loc Code

GA

600

124983

600

ST293

703

124968

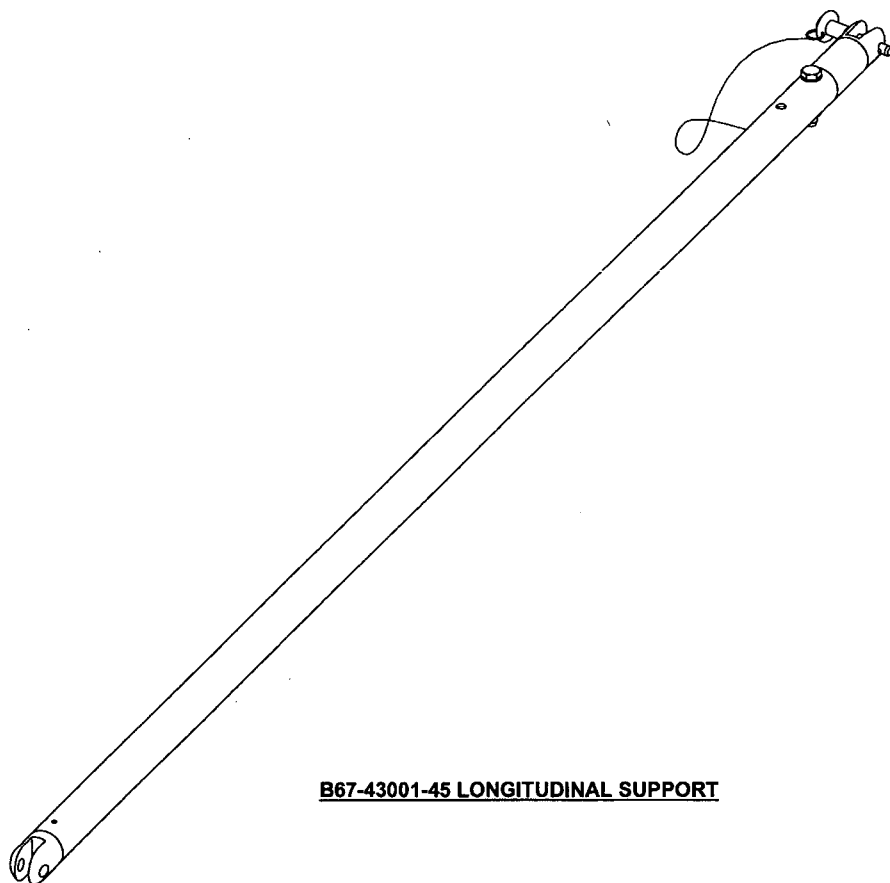
703

2

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Shop Packet Print

Page 3



B67-43001-45 LONGITUDINAL SUPPORT

ITEM	QTY -45	P/N	DESCRIPTION
1	X	B67-43001-45	LONGITUDINAL SUPPORT
3	1	B67-43001-97	CLEVIS
4	1	B67-43001-357	TUBE ARM
5	1	D3447-1	ROUND SPACER
6	1	D3447-5	CLEVIS
8	1	30345T21	LANYARD
9	1	AN4-13A	BOLT
10	1	CR3213-4-2	RIVET (OR BSP43-2)
11	1	MS17984-C410	QUICK RELEASE PIN
12	1	MS21042L4	NUT
13	1	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)
14	2	NAS1149D0416J	WASHER
15	1	NAS1149DN416J	WASHER

MF
#111104
#14-01-09

RELEASED
2009-08-24

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 13 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.25
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-45 TITLE LONGITUDINAL SUPPORT SCALE NTS DATE 09.06.25 COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		
DRAWN				
CHECKED	AS			
MFG. APPR.	AS			
APPROVED	AS			
DE APPR.	N/A	REV. C SHEET 1 OF 2		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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B67-43001-97
2 CLEVIS

B67-43001-357
2 TUBE ARM

10 CR3213-4-2 RIVET
NAS1149DN416J WASHER
(30345T21 LANYARD NOT SHOWN
ON THIS VIEW FOR CLARITY)

D3447-1
ROUND SPACER

AN4-13A BOLT
NAS1149D0416J WASHER, 2X
MS21042L4 NUT

9

0.50
8

MS171534 2 8
SPRING SLOTTED TENSION PIN

9

10 30345T21 LANYARD

MS17984-C410
QUICK RELEASE
PIN

9
2 PL

D3447-5
CLEVIS

B67-43001-45 LONGITUDINAL SUPPORT

RELEASED
2009-09-24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs
- 8) PRIOR TO POWDER COAT, ALIGN B67-43001-97 ON B67-43001-357 AS SHOWN AND DRILL A $\phi 0.129$ HOLE THROUGH BOTH PARTS. FASTEN B67-43001-97 TO B67-43001-357 USING MS171534 SPRING SLOTTED TENSION PIN.
- 9) MASK PRIOR TO POWDER COAT
- 10) BEFORE OR AFTER POWDER COAT, DRILL A $\phi 0.129$ HOLE IN B67-43001-357 TO INSTALL THE LANYARD. DRILL THROUGH ONE WALL ONLY. AFTER POWDER COAT, INSTALL 30345T21 LANYARD ON B67-43001-357 AS SHOWN USING CR3213-4 TYPE RIVET AND NAS1149DN416J WASHER.

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AD	B67-43001-45	SHEET 2 OF 2
APPROVED	N	TITLE	SCALE
DE APPR.	N/A	LONGITUDINAL SUPPORT	NTS
DATE	09.06.25	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Training									
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Unapproved									

FAULT CATEGORY

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